

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029701
Date Inspected: 17-May-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	As noted below	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	SAS Tower	

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA Inspector randomly observed ABF welder Jose Torres #6235 perform the Shielded Metal Arc Welding (SMAW) process on the Luminaire Pedestal Posts located at 11E PP97.5-E5. The welder was observed utilizing WPS ABF-D1.5-F1200A-Revision 1. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 134 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Xiao Hua Luo #1291 perform the SMAW process on the PS3 pipe brackets at the Bike Path located at locations PP111, PP113 and PP115. The welder was observed utilizing WPS ABF-D1.5-F1200A-Revision 1. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 136 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

FW Spencer welder Tim Esquivel #8348 was observed performing SMAW welding on 4" schedule 40 pipe on the

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Bike Path located at PP21. The welder was observed utilizing WPS-1-12-1 and the welder was observed pre-heating the surface area to be welded prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. This QA Inspector made random observations throughout the shift and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

This QA Inspector performed a Deck survey of the surface condition of "A" deck from OBGs 1E PP8 E2.6 - E5 to 3E PP29-E2.6 to E3.6. This inspection was conducted in conjunction with Smith Emery Quality Control personnel and impact sites as well as arc strikes and any irregularities was measured for depth and length as well as location and recorded for a repair procedure.

This QA Inspector randomly observed ABF welding personnel perform the Carbon Arc Gouging (CAG) method to remove the Bike Path Panel lifting lugs at locations PP108.5, PP109.5, PP110.5 and PP111.5. Upon completion of removal personnel utilized disc grinders to remove excess material to a flush surface condition. This work is currently in progress.

This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT). QC Inspectors were observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations on this date were relevant to work performed.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

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Reviewed By: Reyes,Danny

QA Reviewer